

Work Order ID 138890

138890

Page 1

Friday, November 13, 2015 11:35:48 AM

Item ID: D2873-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Nut Plate Assembly

Start Date: 11/13/2015 Start Qty: 20.00

20

Cust Item ID:

Required Date: 11/13/2015 Req'd Qty: 20.00

20

Customer:

Reference:

Run Start

NR1

Stop

NR2

Approvals: Process Plan: MCS Date: NOV 16 2015 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2873	Rev A

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 1.000" x 0.375" x 3.700" long

20 0 15/12/15

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.05

HAAS CNC vertical machine #1

Machine as per Folio FA and Dwg D2873 Identify as D2873-3

Dwg Rev A Folio Rev AA

20 0 15/12/16

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

20 0 15/12/16

DAS
20
9-89 15-12-17

DAS
20
9-8 15-12-17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																		
Description Work Order Deviation				Disposition			Completed By																		
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐																		

DQA: _____ Date: _____



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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :																							
Misidentified ☐	Past Due ☐																								

Work Order ID 138890

138890

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Friday, November 13, 2015 11:35:48 AM

Item ID: D2873-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Nut Plate Assembly
 Start Date: 11/13/2015 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 11/13/2015 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160						20	0	15-12-22	JH
HandFinish	Memo	0.01							
Hand Finishing									
170	QC7-Inspect Chemical Conversion Coat	0.00							
170						20x		15/12/22	DAS 36 9-89
QC	Memo	0.00							
Quality Control									
180	Small Fab	0.00							
180						20x		15/12/22	DAS 36 9-89
Small Fab	Memo	0.01							
Small Fab	1-Assemble as per Dwg D2873 2-Identify as D2873-043								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 138890***138890***

Page 4

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp DAS
190	QC5- Inspect part completeness to step on W/O	0.00							9 9-89
190						(20)	15-12-23		
QC	Memo	0.01							
Quality Control									
200	Identify as per dwg & Stock Location: <u>LG50</u>	0.00							DAS 41 9-89
200						20			
Packaging	Memo	0.00							15-12-24
Packaging	LOCATION : LG050								
210	QC21- Final Inspection - Work Order Release	0.00							
210						ML5	JAN 04 2016		
QC	Memo	0.03							
Quality Control									

ML5 JAN 04 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :																							
Misidentified ☐	Past Due ☐																								

Picklist Print

Friday, November 13, 2015 11:35:47 AM

Page 1

Work Order ID: 138890

138890

Parent Item: D2873-043

D2873-043

Parent Item Name: Nut Plate Assembly

Start Date: 11/13/2015

Required Date: 11/13/2015

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.375X01.00 0		Purchased	No			180	f	33.0700	0.3083	6.490526			

M6061T6B0 375X01 000

6061T6 BAR .375 x 1.00

Location	Loc Qty	Loc Code
MAT	9.07	
m133265	9.07	
MAT001	24	
m133587	24	

MS20426AD4-6

Purchased

No

180

Each

2,073.000

6

120

MS20426AD4-6

Rivet

Location	Loc Qty	Loc Code
GA	1594	
M128812	16	
M133234	1578	
ST311	479	
124392	252	
M128812	69	
M132536	158	

OK 15/12/15

6.5

DAS
36
9-89

15/12/22

120

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
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Picklist Print

Page 2

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Work Order ID: 138890

138890

Parent Item: D2873-043

D2873-043

Parent Item Name: Nut Plate Assembly

Start Date: 11/13/2015

Required Date: 11/13/2015

Start Qty: 20.00

Required Qty: 20.00

MS21075L5

Purchased

No

100

Each

208.0000

3

60

MS21075L5

Nut Plate

15/12/22
DAS
36
9-89

Location

Loc Qty

Loc Code

CCK007

150

m133577

150

GA

8

m133284

8

ST298

50

m133498

50

60

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Root Cause		FAULT CATEGORY			
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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

DART AEROSPACE LTD		Work Order: 128890
Description: Radius Block		Part Number: D2873-3
Inspection Dwg: D2873	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.502	✓		Vern 11-06	
2.000	+/-0.010	2.000	✓		"	
0.750	+/-0.010	.750	✓		"	
1.000	+/-0.010	1.000	✓		"	
0.250	+/-0.010	.250	✓		"	
1.000	+/-0.010	1.000	✓		"	
2.000	+/-0.010	2.000	✓		"	
3.000	+/-0.010	3.000	✓		"	
Ø0.128	+0.005/-0.001	Ø.129	✓		"	
0.359	+/-0.010	.358	✓		"	
Ø0.316	+0.006/-0.001	Ø.317	✓		"	
1.000	+/-0.010	1.000	✓		"	
0.250	+/-0.010	.242	✓		"	
0.061	+/-0.010	.057	✓		"	
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	Ø.232 x .125	✓		"	

DAS

Measured by: <i>ML</i>	Audited by: <i>44</i>	Prototype Approval:	N/A
Date: 15/12/17	Date: 15/12/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-043	KJ/JLM	<i>[Signature]</i>

